

Date: Wednesday, 06/09/2006 11:05:17 AM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GPS BOTTOM MOUNTING
Job Number : 28422	
Estimate Number : 12518	
P.O. Number :	Part Number : D35301
This Issue : 06/09/2006 S.O. No. :	Drawing Number : UNDER REVIEW <i>EC 06-09-05</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : N/A
Previous Run :	Material :
Written By : <i>EC</i>	Due Date : 13/09/2006 Qty: 2 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 06-08.30 EC	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S040	6061-T6 .040 Sheet
Comment: Qty.: 0.4812 sf(s)/Unit Total : 0.9624 sf(s) 6061-T6 .040 Sheet (M6061T6S040) Batch: <i>119380</i> <i>MM 06 09 06</i>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg P3530 Dwg Rev: <i>Pre</i> Prog Rev: <i>Pre</i> 2-Deburr if necessary <i>MM 06 09 06</i> (2)		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>MM 06 09 06</i> (2)		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <i>EC 06-09-06</i>		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>AM 06-09-07</i> (2)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 06/09/2006 11:05:17 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GPS BOTTOM MOUNTING

Job Number: 28422

Part Number: D35301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-09-21

(2)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 06 09 21

(2)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

See eng. use only

EC 06.09.19

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Inspection Level 21

07/03/09

Job Completion



U 07.03.09

Eng Approval

CB 07.03.08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

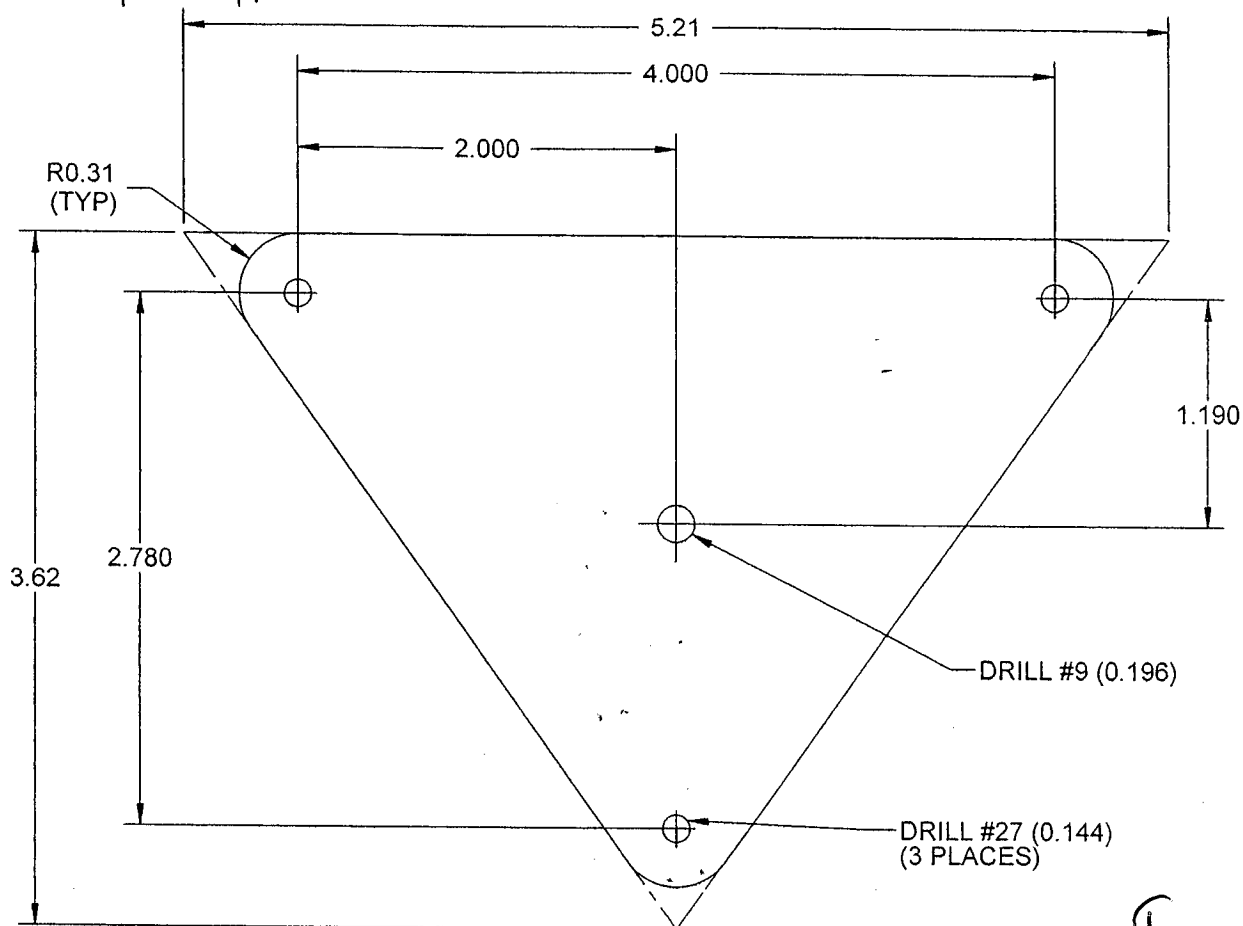
PRELIMINARY ISSUE

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3530	REV. A SHEET 1 OF 2
DATE 06.06.21		TITLE GPS BOTTOM MOUNTING	SCALE 1:1
A	06.06.21	NEW ISSUE	

UNDER REVIEW

06.08.22 cb

prototype



D3530-1F FLAT PATTERN

D3530-1 BASE PLATE

EST
Powe
Prog-

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) 0.040 SHEET
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	28422
Description: GPS BOTTOM MOUNTING		Part Number:	3530-1
Inspection Dwg: Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

X

X

[illegible]

Measured by: <i>MM</i>	Audited by: <i>ER</i>	Prototype Approval: <i>CB</i>
Date: <i>06.09.06</i>	Date: <i>06.09.06</i>	Date: <i>07.03.08</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DOC : V/0080151422

DATUM : 2005-04-18

PROD. REF. : 0000175932/001

NRBST : 58848/01

PAGINA : 1/ 4



KEURINGSRAPPORT

KLANT : COPPER AND BRASS SALES
CORPORATE SERVICES DIVISION
SOUTHFIELD, MI USA

Corus Aluminium N.V.
A. Stodetlaan 87, 2570 Duffel - Belgium
Tel. 32 (0)15 30 21 11 - Fax (0)15 30 27 94

UW ORDERNUMMER : PO3944 (COPPER'S PO#CC1837)
ONS ORDERNUMMER : 58848/01
DOCUMENT NUMBER : V/0080151422

SPECIFICATIES: ALU SHEETS (STENC-) AA 6061-T6 AMS-QQA-250/11 AMS 4027M ASTM B209-04
AFMETINGEN : 144" X 48" X 0,04"
ARTIKEL NR.:

ROL- NUMMER	GEUT- NUMMER	CHEMISCHE ANALYSE (%)							
		MIN	SI	FE	CU	MN	MG	CR	TI
		MAX	0,40		0,15		0,8	0,04	
			0,8	0,7	0,40	0,15	1,2	0,35	0,15
001	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,25
002	7124901		0,67	0,4	0,22	0,09	1,1	0,16	0,01
								0,02	0,01

ANDERE : ELK
TOTAAL :

MIN
MIN 0,05 MAX
0,15 MAX

TEST- NUMMER	MECHANISCHE EIGENSCHAPPEN
	1 N/MM2 = 1 MPA = 0,1 HBAR = 0,102 KG/MM2 = 0,145 KSI
	/A = ACHTER /M = MIDDEN /V = VOOR /O = RANDOM
	MIN MAX RM KSI RP02 KSI A %
	42 35 10
001	/A 47 39 16
001	/M 47 39 15
001	/V 47 39 16
002	/A 47 39 16
002	/M 48 40 16
002	/V 48 39 16

COPPER AND BRASS SALES

SOLD TO: C & B

DATE: 12/16 QTY. 20

CUSTOMER PO: 0000624

SHIPPER NO: 4V3128

BY: 8

Corus Aluminium Rolled Products - Corus Aluminium Extrusions